

Date: Wednesday, 2/8/2006 7:06:47 AM  
 User: Linda Lacelle

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	DOUBLER
Job Number	25731		Part Number	D314095
Estimate Number	11467		Drawing Number	D3140 REV C
P.O. Number	N/A		Project Number	N/A
This Issue	2/8/2006	S.O. No. : N/A	Drawing Revision	C
Prsh Rev.	NC		Material	N/A
First Issue	N/A	Type : SMALL /MED FAB	Due Date	2/15/2006
Previous Run	N/A		Qty:	12
Written By	<u>See Comment Below</u>			Um: Each
Checked & Approved By	<u>W</u>			
Comment	Est. A02.04.30 New Issue NG			

## Additional Product

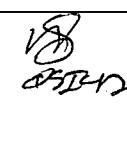
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet  Comment: Qty.: 0.1549 sf(s)/Unit Total : 1.8585 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 ( QQ-A-250/4 ) .032" thick ( M2024T3S.032 ) 6.40" x 3.81" flat pattern ref. Batch <u>M12758</u>
2.0	SHEAR	SHEAR  Comment: SHEAR Cut as per dwg D3140
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1  Comment: HAAS CNC VERTICAL MACHINING #1 Cut as per dwg D3140 Deburr. No sharp edges Form as per dwg <u>Weld by</u> <u>Ward</u> <u>u</u> <u>Form : SP 06/02/08</u> <u>ml 06/02/08</u> <u>12</u>
4.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>FF. 06. 02. 17</u> <u>12</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 02/02/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-02-08	3	Parts are .090 short on 2.1 dim. Parts are 2.010. Top dim is important and is good.	<input checked="" type="checkbox"/> 02/02/08	Parts are acceptable <u>bottom dim</u>	SB 06/02/08	 06-02-08	 02/02/08	 06-02-08

NOTE: Date & initial all entries

Date: Wednesday, 2/8/2006 7:06:47 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25731

Part Number: D314095

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/1 06 02 17

7.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ✓

C Loc 02/17

12

8.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Inspection Level 21

5/15 06/02/20

12

DP 06/02/20

12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3810

GRAIN  
DIRECTION



6.40

REFERENCE ONLY